

## **ABSTRACT**

A secure optical data disc comprising an electronic article surveillance tag embedded within a layered disc structure comprising first and second substrates is disclosed. The tag is placed within a non-readable zone (i.e., one that does not have data tracks) of the secure disc.

5 Layer-wise, the tag is either sandwiched between the two substrates or alternatively embedded within one of the two substrates. In the case where the tag is sandwiched between first and second substrates, a bonding layer occupies a space radially outward from the tag. The bonding layer holds the first and second substrates together thereby forming the secure disc.

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